

Date: Tuesday, 12/20/2005 3:37:01 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LATCH BRACKET		
Job Number	: 25326		Part Number	: D2583		
Estimate Number	: 10994		Drawing Number	: D2583 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/20/2005	S.O. No.	: N/A		Drawing Revision	: B
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 12/20/2005	Type	: MACHINED PARTS		Due Date	: 1/15/2006
Previous Run	: N/A		Qty:	100	Um:	Each
Written By	: <u>SEE APPROVAL BELOW</u>					
Checked & Approved By	: <u>SEE ABOVE USER</u>					
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM					

Additional Product

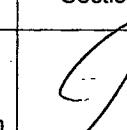
Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	M5052H32S040	5052-H32 .040 Sheet		
		Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) Batch: M17835		
2.0	SHEAR	SHEAR		
		Comment: SHEAR Cut blank: 4.000" x 2.130" Grain offset 10° along 3.188"	JL 06.01.08 100	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2583	JL 06.01.08 100	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL 06.01.08 100	
5.0	BRAKE NC	NC BRAKE		
		Comment: NC BRAKE Deburr Form on CNC Brake as per Dwg D2583	SB 06/01/17 99 DL 06/01/13 100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/17	5	I piece was bend out of tolerance		Scrap & destroy	SBS 06/01/17			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:37:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 25326

Part Number: D2583

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/01/00 21 99

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-02-23

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W 06/02/23 99

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST189

PC 06/02/23 98

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

IP 06/02/24

Job Completion



u 06/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

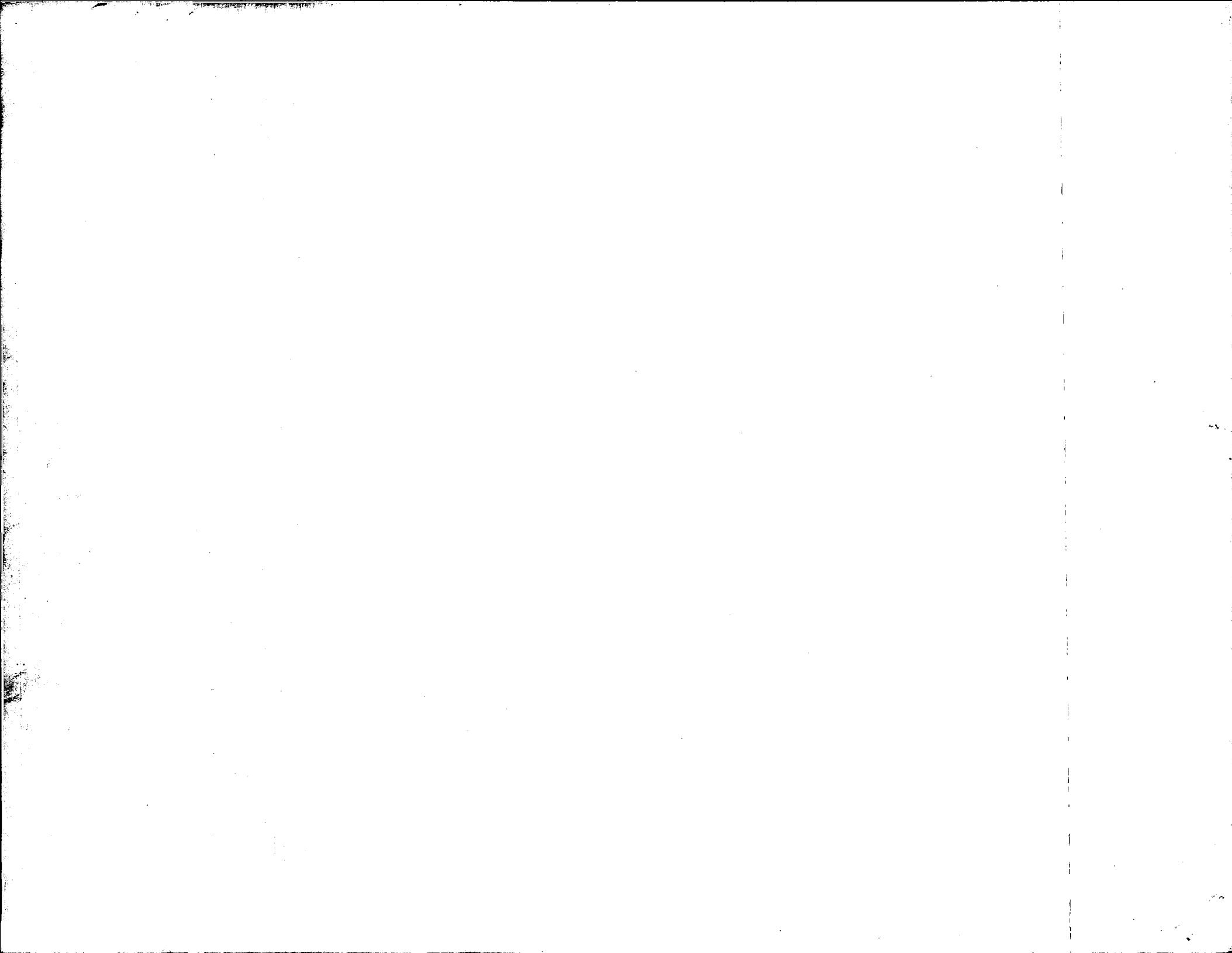
DART AEROSPACE LTD	Work Order:	25326
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583 Rev: B		Page 1 of 1

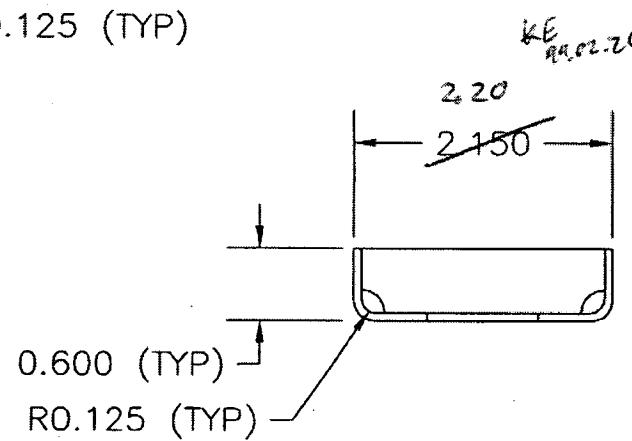
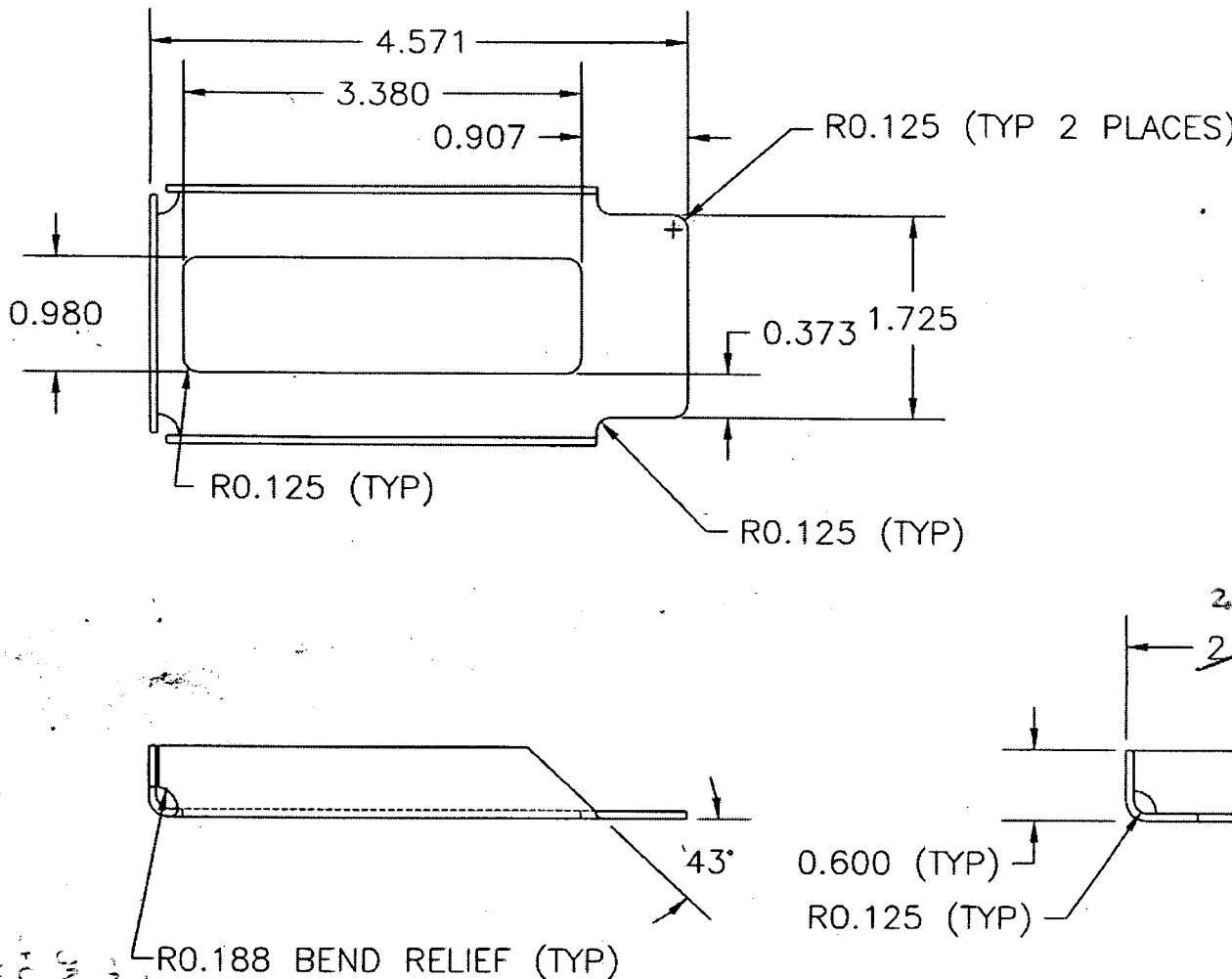
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L.	Audited by:	J.L.	Prototype Approval:	N/A
Date:	06.01.08	Date:	06/01/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	





MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 [Ke 99.02.25]

D A C O P Y
 G E N E R A T E D

DESIGN MIKE M.	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JP</i>	APPROVED <i>KE</i>	DRAWING NO. D2583
DATE 99.02.22		SHEET 1 OF 1
A	96.07.10	REV. B
B	99.02.22	TITLE LATCH BRACKET SCALE 2:3 CHANGE OF FINISH (PER TSR A887)